

Date: Thursday, 5/25/2006 3:26:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 27244					
Estimate Number	: 10192					
P.O. Number	: N/A		Part Number	: D2171		
This Issue	: 5/25/2006	S.O. No. : N/A	Drawing Number	: D2171 REV. D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: N/A		Material	: N/A		
Written By	: See Comment Below		Due Date	: 6/15/2006 Qty: 100 Um: Each		
Checked & Approved By	: JF 06.05.25 N					
Comment	: Est: F 01.11.29 Reformat SM/EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1352

CLO 6105/30

(100)

Laser cut as per Dwg D2171

Material: 304/316 SS 0.063" thick

Material release note required

2.0	D2171F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Rec/6/05 (100)

Pass 705 (100)

Comment: DIMENSIONAL CHECK

(4.158" center to center)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2- Bend as per Dwg D2171

3- Tumble

AI READY
BENT.

Sad 06:07:05 (102)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 15 Date: 06/07/05
 NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/25/2006 3:26:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 27244

Part Number: D2171

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 06/07/05 102

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 219

PJY/15 102

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/05 102

Job Completion



U 06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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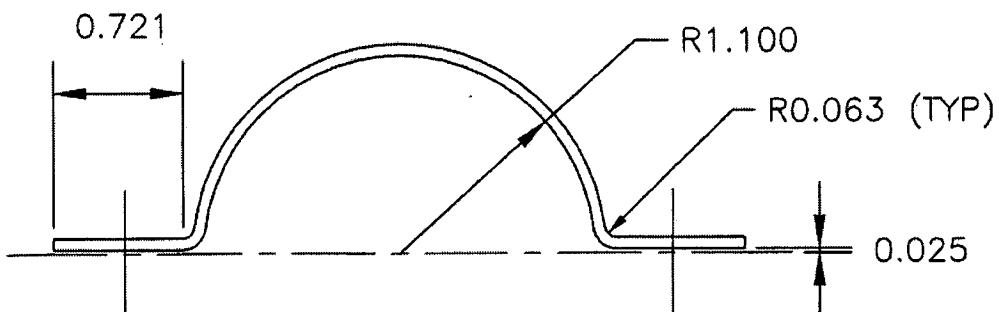
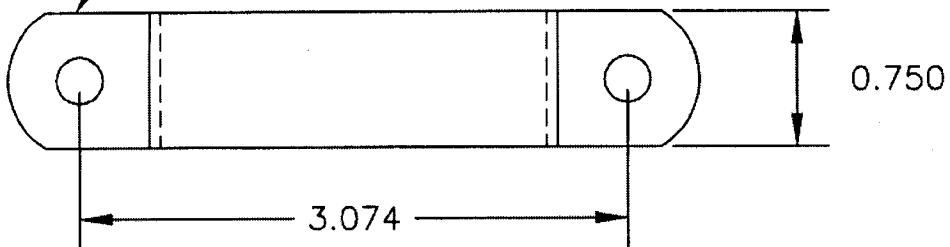
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

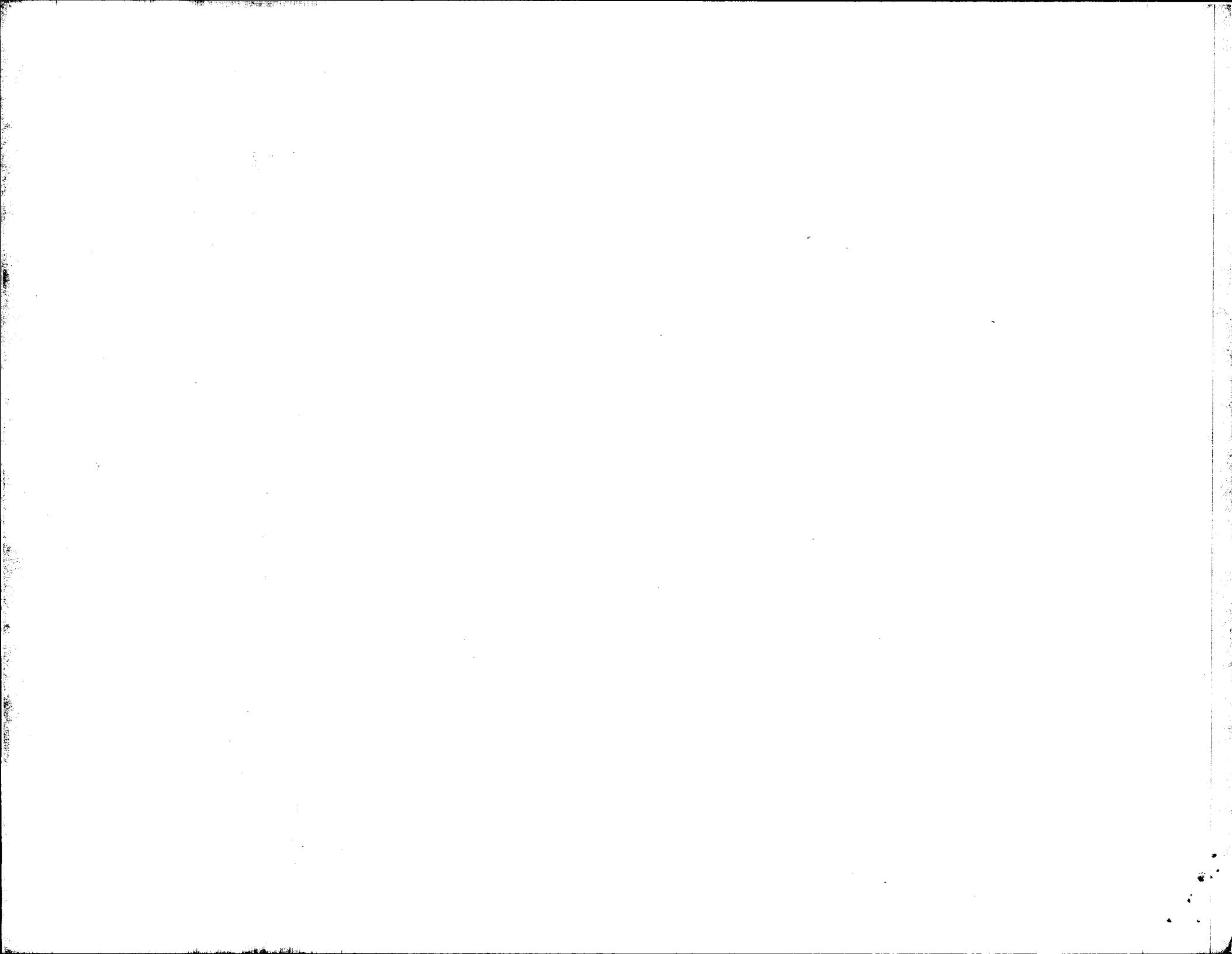
RELEASED
99.03.11 KE

 PUNCH ENDS PER SPEC
 CONTROL DRAWING D2727


MATERIAL: 304/316 SS 0.063 THICK
 FLAT LENGTH: 4.968 END-END
 4.158 HOLE-HOLE



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27244



CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Member de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO **30144270** SHIPPING MEMO **0340503**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
—	100 PCS	PO00001352	D2171	D	CLAMP	D
MATERIAL	SUPPLIED BY				MAT. REL. NO.	
S.S.T 304	TW METALS / AK STEEL				H/N # 7360176 ATT'D	

PROCESS	PROCESSOR	RELEASE NOTE #
1 FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2		
3		
4		
5		
6		
7		
8		
9		

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **03 JULY 2006**

G.F.I. Q.C. REP.

B. Somac

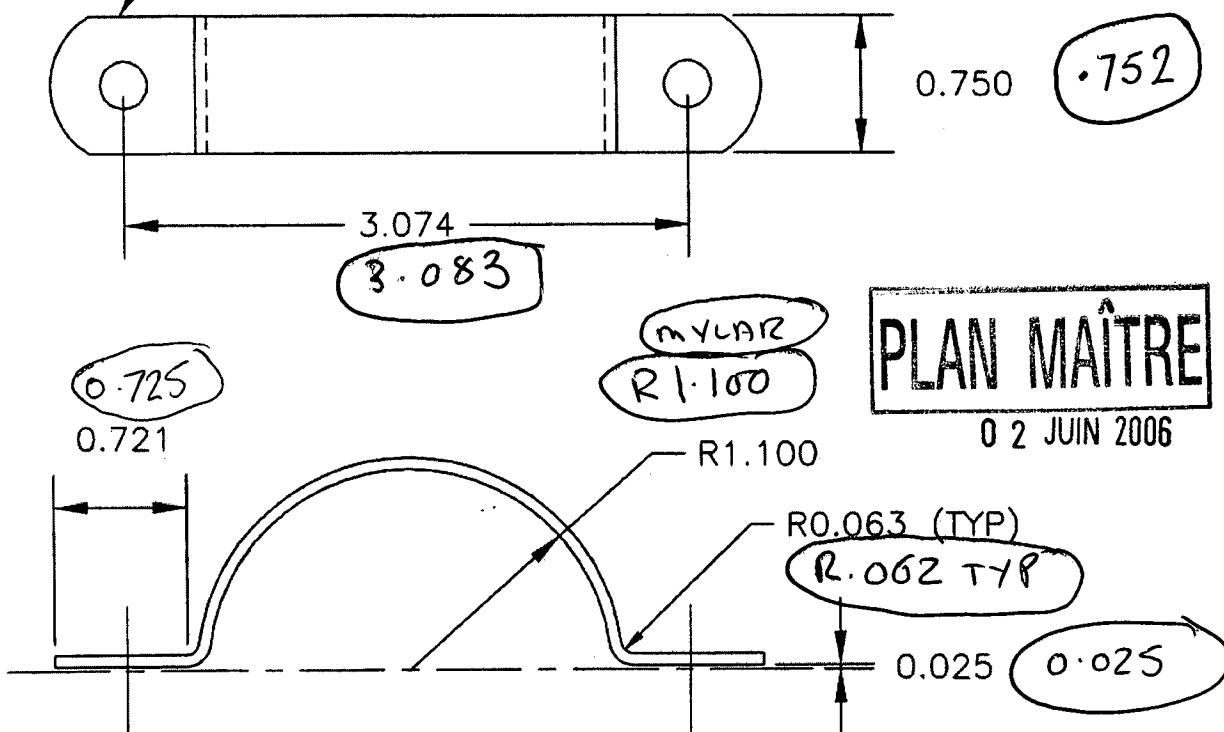


DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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RELEASED
99.03.11 KE

 PUNCH ENDS PER SPEC
 CONTROL DRAWING D2727

Comply.

 MATERIAL: 304/316 SS 0.063 THICK
 FLAT LENGTH: 4.968 END-END
 4.158 HOLE-HOLE

D